

Work Order ID 65198

January 7, 2011 3:49:52 PM



RUSH

Item ID: D3859-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/10/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *mt*

Date: *11-07-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 11Dwg Rev: *A* Prog Rev: *A* 12-

Deburr if necessary

B11-1-10

(2)

304.063

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 u10110

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod
Batch: 11114509 L2-Weld hard facing as per Dwg D3859 A/R
2059B Hard Coat rod Batch: 1116468 *****use
D19462 for welding*****

EL 11-1-11

(X2)

140

0.00



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

Memo

0.00

PC 11-01-11

(X2)

150

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Sulochi

(X2)

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

11112588

Memo

0.00

Powder Coating

START TIME:

1:25

DOVEN TEMPERATURE:

FINISH TIME:

1:55

2 BL 11-01-11

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 1/6/11

2 /

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PP65199

Cupot/12 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 1/14/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/12
MF

11-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 7, 2011 3:49:52 PM

Page 1

Work Order ID: 65198

Parent Item: D3859-041

Parent Item Name: Wearplate




Start Date: 1/10/11

Required Date: 1/14/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet.063		Purchased	No			100	sf	34.8100	0.85	1.7			



B1-1-10

Location

Loc Qty

Loc Code

MAT

34.81

111323

0

115953

34.81

115953

D3009-3

Manufactured

No

130

Each

117.0000

6

12



EL 11-1-11

Cup

Location

Loc Qty

Loc Code

WA

117

42377

117

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

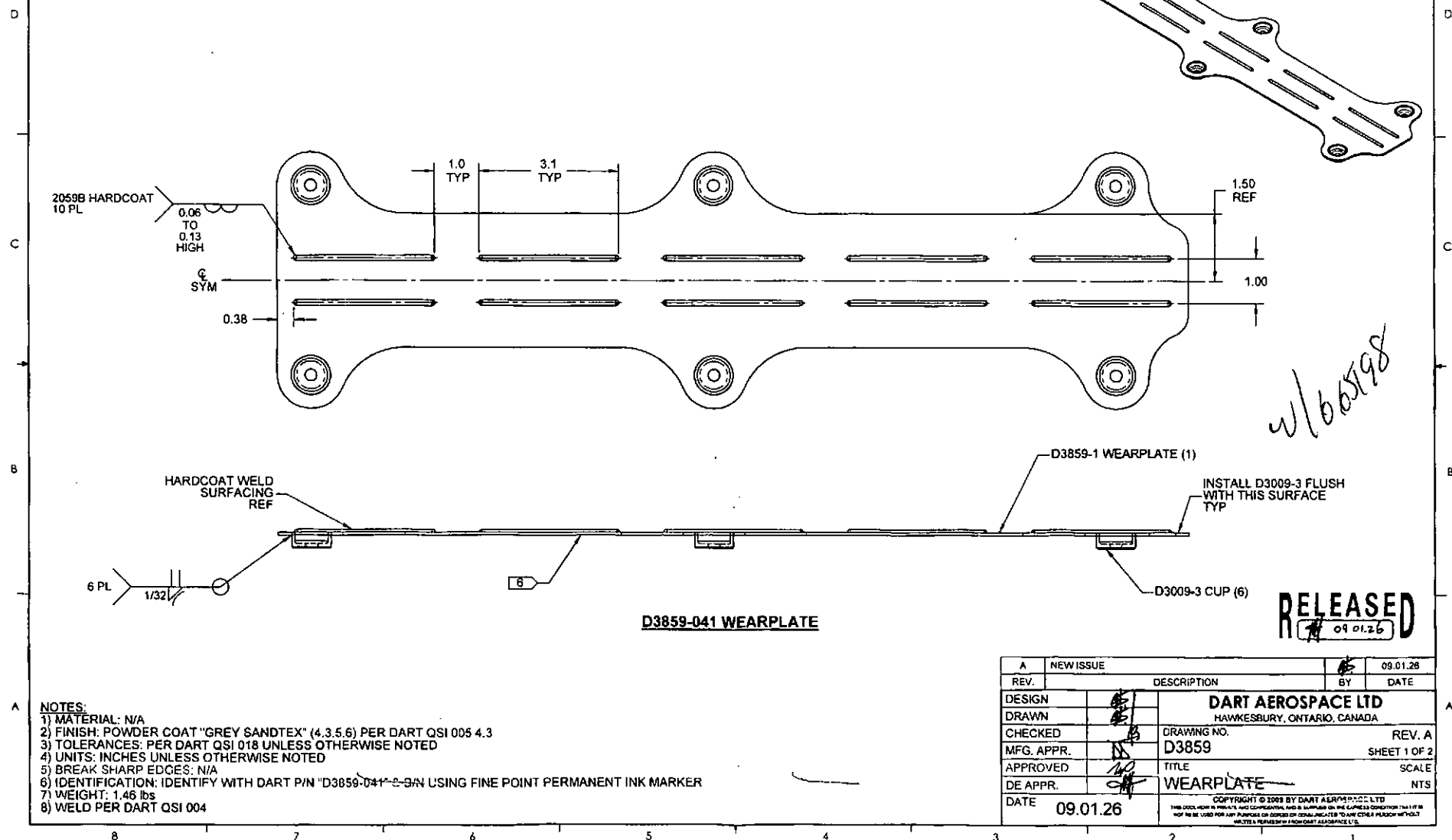
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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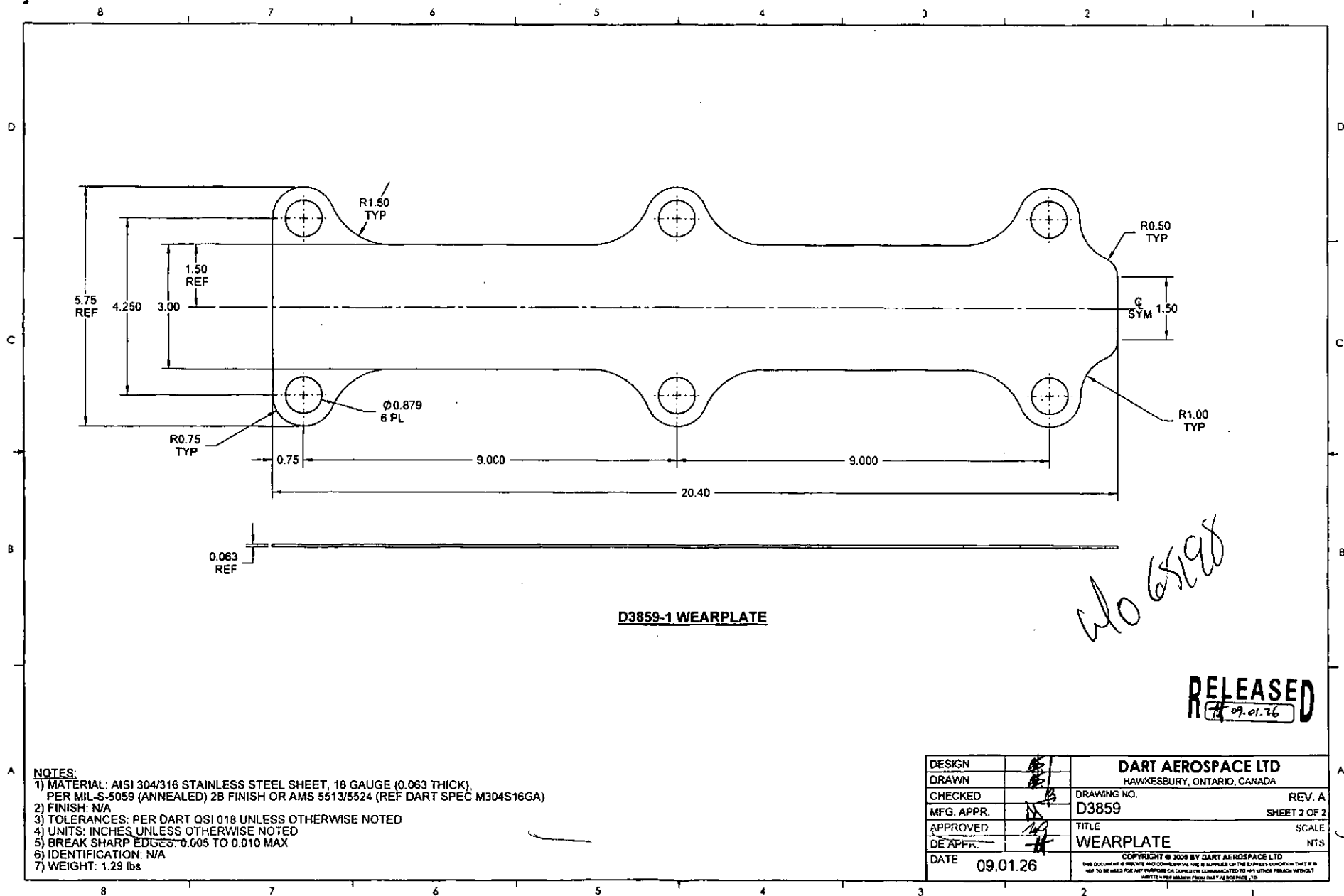
NOTE: Date & initial all entries

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP



A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3859	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		WEARPLATE	NTS	
DATE	09.01.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD		

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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK),
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M3D4S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3859	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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